

Work Order ID 75107

75107

Page 1

October-17-11 1:27:39 PM

Item ID: D3874-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Protector
 Start Date: 17/10/2011 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3874	A

100 0.00
100
 HandThermo Memo 0.00 x3 DL
 Hand Finishing Thermoforming I-Cut Sheet to required Blank size 11/11/02

105 0.00
105
 HandThermo Dry Material Memo 0.00 x3 DL
 Hand Finishing Thermoforming Dry Sheet as per QSI022 POLYCARBONATE 11/11/02
 Temp: 240°F
 Time IN: 7:30 AM
 Time OUT: 11:30 PM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

NS1

Stop *NS2*

3

Cust Item ID:

3

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

110

0.00

110

0.00

Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up

2-Pre-heat Tool to required temp.

3-Thermoform as per Dwg and Folio #FTA039 using tool DT9474

Dwg Rev: **A**

Folio Rev: 2

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

0,00

QC

Quality Control

Memo

Visually inspect part for proper formation and texture

130

QC8- Inspect parts - second check

0.00

130

0.00

QC

Quality Control

Memo

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 17/10/2011 **Start Qty:** 3.00 ***3***

Required Date: 04/11/2011 Req'd Qty: 3.00 *3*

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

PAP 75110

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

11/11/79

MF

11-11-04

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Picklist Print

October-17-11 1:27:44 PM

Page 1

Work Order ID: 75107

75107

Parent Item: D3874-2

D3874-2

Parent Item Name: Floor Protector

Start Date: 17/10/2011

Required Date: 04/11/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev. A 09.02.06 New Issue DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	1,848.384	4.38	13.14			

MI FXS 118-90318-08

Lexan Sheet

**

Location

Loc Qty

Loc Code

therm

1848.384621

1848.38462

113127

13.1459 At.

11/11/03

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	75107
Description: Floor Protector		Part Number:	D3874-2
Inspection Dwg: D3874	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>7/16"</u>	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	<u>11/11/03 Dk</u>	Date:	<u>11/11/03</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	<u>0.025</u>	✓		CAL THDT	
0.065	Min	<u>0.100</u>	✓		CAL THDT	
0.5	Min	<u>0.52</u>	✓		USE DL-02	
21.9	REF	<u>21.9</u>	✓		TAPE DL-01	

Measured by:	<u>Dk</u>	Date:	<u>11/11/04</u>
Audited by:	<u>JB</u>	Date:	<u>11/11/04</u>
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>[Signature]</u>

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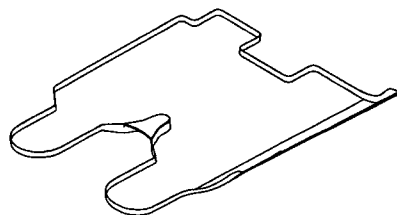
W/O:		WORK ORDER CHANGES					
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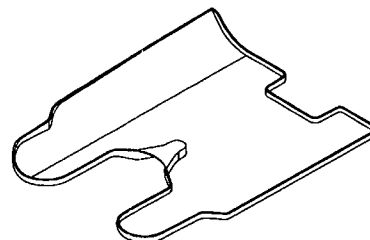
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D3874-1 FLOOR PROTECTOR



D3874-2 FLOOR PROTECTOR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 75107 M.L.J

11/10/17

RELEASED
09/01/29

A	NEW ISSUE	PH	09.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3874	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR	NTS
DATE	09.01.29	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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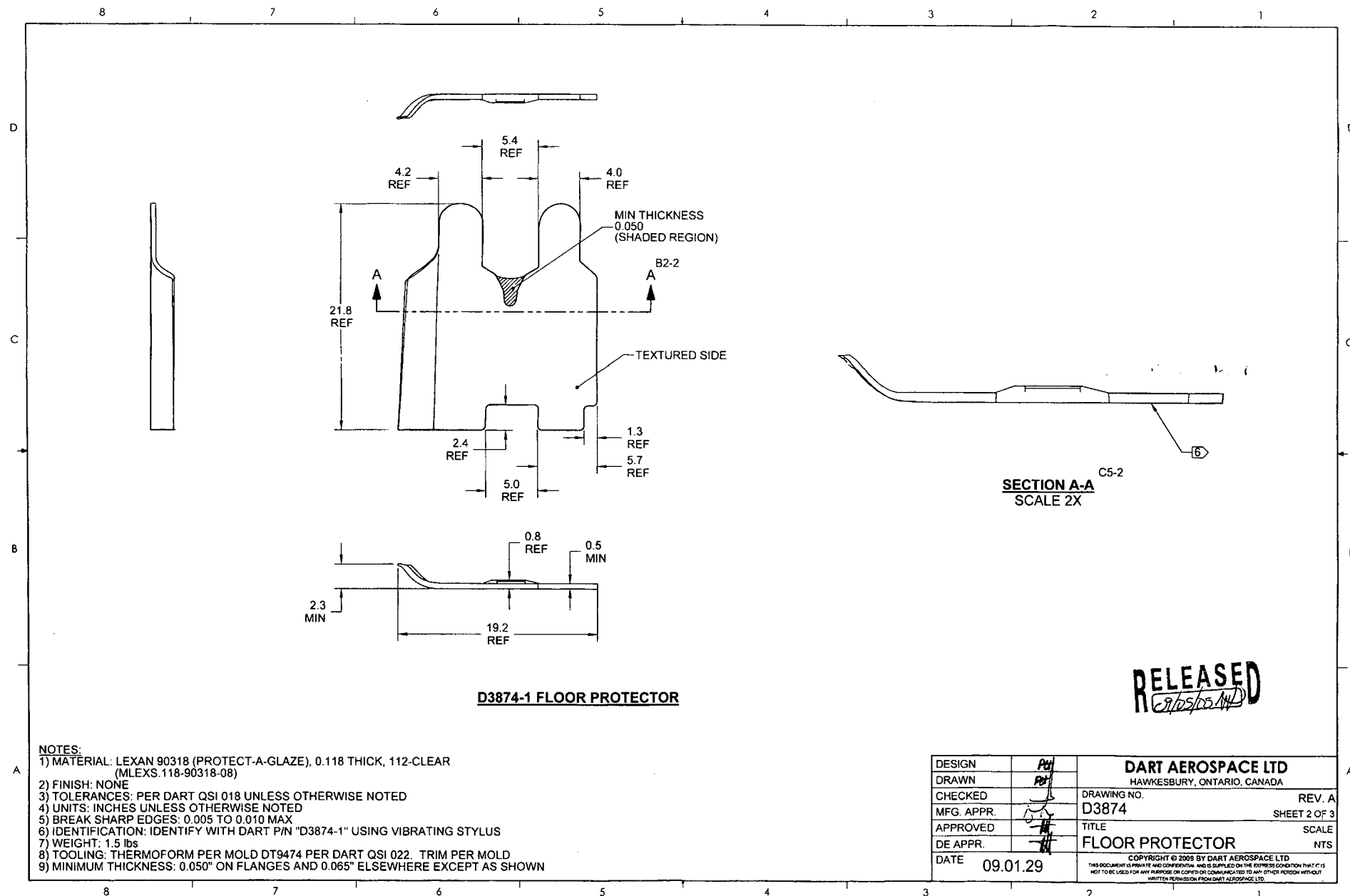
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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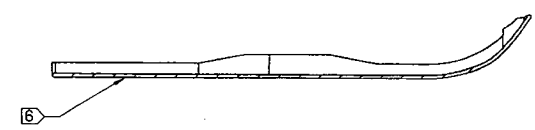
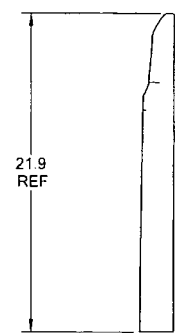
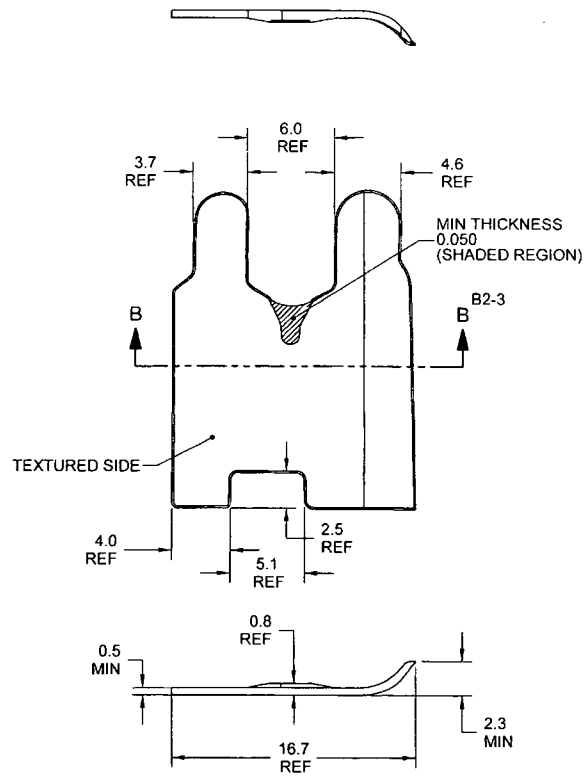
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SECTION B-B
SCALE 2X

D3874-2 FLOOR PROTECTOR

RELEASED
09/05/09

- NOTES:**
- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
 - 7) WEIGHT: 1.5 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

DESIGN	REV	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	REV	DRAWING NO.	REV. A
CHECKED	REV	D3874	SHEET 3 OF 3
MFG. APPR.	REV	TITLE	SCALE
APPROVED	REV	FLOOR PROTECTOR	NTS
DE APPR.	REV	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
DATE	09.01.29	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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